

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002702**Date Inspected:** 29-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

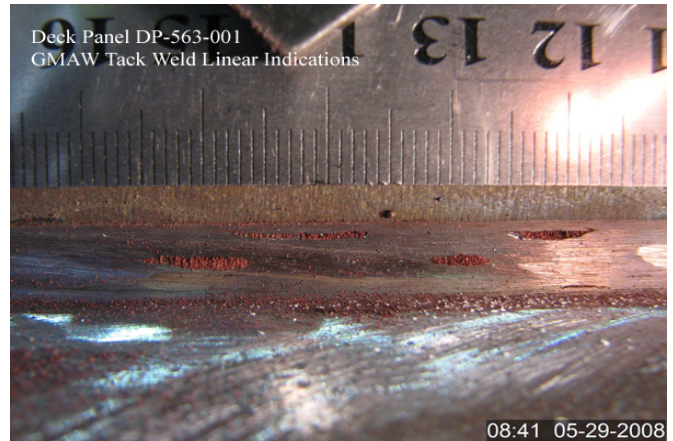
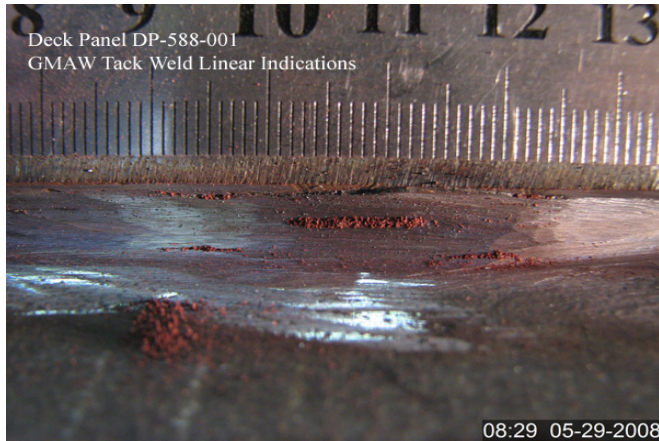
The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

The Quality Assurance Inspector performed magnetic particle inspection to the tack welds on weld 8 of Deck Panel DP-588-001. Weld 1 contains 21 tack welds. Of the 21 tack welds, 9 appeared to contain linear indications indicative of cracks. In addition, The Quality Assurance Inspector performed magnetic particle inspection to the tack welds on weld 1 of Deck Panel DP-563-001. Weld 1 contains 21 tack welds. Of the 21 tack welds, 14 appeared to contain linear indications indicative of cracks. ABF representative Warren Buehler was notified by the Quality Assurance Inspector. Mr. Buehler stated that ABF has recommended that all the tack welds be magnetic particle tested. At completion of the Quality Assurance Inspectors shift ZPMC had begun repairing the indications by grinding and retesting by the magnetic particle testing method. Below are two digital photographs of cracked GMAW tack welds located by the magnetic particle testing method.

The Quality Assurance Inspector witnessed ZPMC repair the indications by grinding and retesting by the magnetic particle method. ZPMC is only repairing the indications that the Quality Assurance Inspector is observing.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

As stated in the contents of the above report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (916) 227-5719, who represents the Office of Structural Materials for your project.

Inspected By:	Bertlesman,Greg	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
